

Work Order ID 111722

111722

Page 1

Monday, January 20, 2014 2:35:33 PM

Item ID: PB67-43001-47 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Base Assembly
 Start Date: 1/20/2014 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/31/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MF. Date: 1-1-20 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-47	Rev C								
100:		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- weld as per dwg B67-43001 using jig								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

QC 14-01-30

2*

② 14-01-31

DAS
9
9-89

② 14-01-31

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: PB67-43001-47

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base Assembly

Start Date: 1/20/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Mer2</u>	0.00							
130									DAS
Packaging	Memo	0.00				②	14.031		9
Packaging									9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-02-05① 14-01-31

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, January 20, 2014 2:35:32 PM

Page 1

Work Order ID: 111722

Parent Item: PB67-43001-47

Parent Item Name: Base Assembly

Start Date: 1/20/2014

Required Date: 1/31/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP Rev C 10.09.28 per rev C
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3440-11 Gusset (Supersedes B67-43001-241)		Manufactured	No			100	Each	5.0000	2	4		PC 14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		5							
				104546		5							
PB67-43001-139 Square Tube		Manufactured	No			100	Each	5.0000	1	2		PC 14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		5							
				100003		5							
PB67-43001-141 Square Tube		Manufactured	No			100	Each	4.0000	2	4		PC 14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		4							
				100002		4							
PB67-43001-143 Square Tube		Manufactured	No			100	Each	2.0000	2	4		PC 14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		2							
				100001		2							
PB67-43001-315 Hook		Manufactured	No			100	Each	15.0000	3	6		PC 14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		15							
				99954		15							

B111736 → (2)

(2)



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

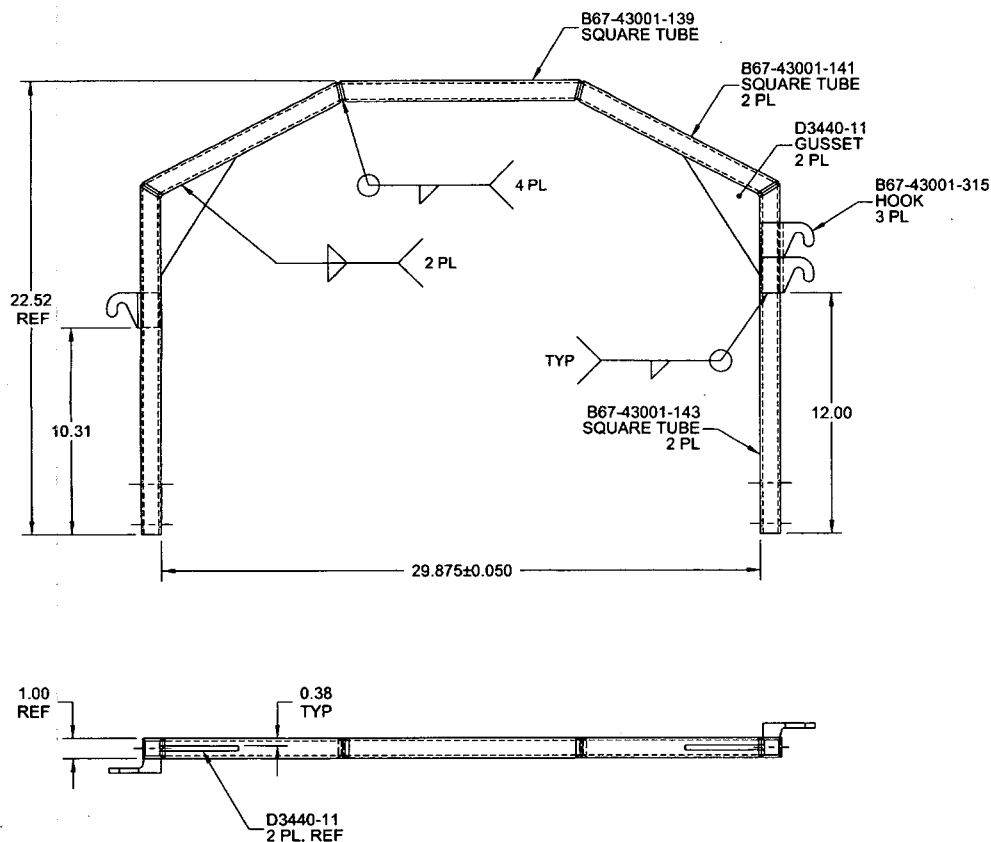
Work Order update only ☐

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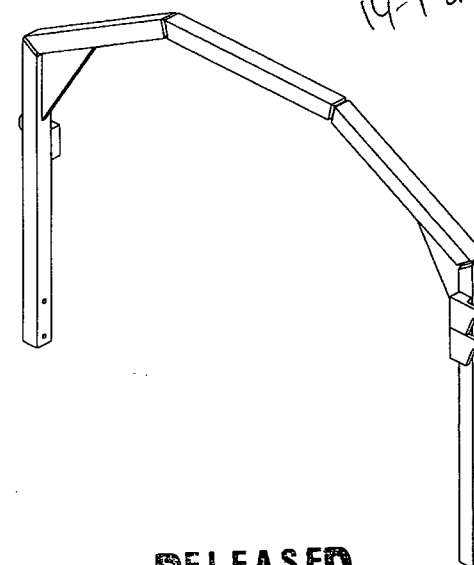


B67-43001-47 BASE ASSEMBLY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.68 lbs
- 8) WELDING: PER QSI 004

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-139	SQUARE TUBE
4	2	B67-43001-141	SQUARE TUBE
5	2	B67-43001-143	SQUARE TUBE
6	3	B67-43001-315	HOOK
7	2	D3440-11	GUSSET



RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED				
MFG. APPR.			DRAWING NO. B67-43001-47	REV. C
APPROVED			TITLE	SHEET 1 OF 1
DE APPR.	N/A		SCALE	NTS
DATE	09.06.10		BASE ASSEMBLY	
COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

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